

Date: Monday, 9/10/2007 1:28:10 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAFFLE & DEFLECTOR ASSEMBLY
Job Number : 34490	
Estimate Number : 12223	
P.O. Number :	Part Number : D3467049
This Issue : 9/10/2007 S.O. No. :	Drawing Number : D3467 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 34092	Material :
Written By :	Due Date : 10/10/2007 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est Rev: A New Issue 06-04-24 JLM	
Est Rev: B As per Rev B 06-05-24 JLM	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D346715 DEFLECTOR



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3467-15	Deflector	B34518

2

mf

2.0 D346713 BAFFLE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-13	Baffle	B28591 x 1mx, B34107 x 4mx

X

mf 07-10-01

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

mf 07-10-01

(5)

4.0 QC11 VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/10/01

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:28:10 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE & DEFLECTOR ASSEMBLY

Job Number: 34490

Part Number: D3467049

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/01

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 07-10-01

7.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07/10/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

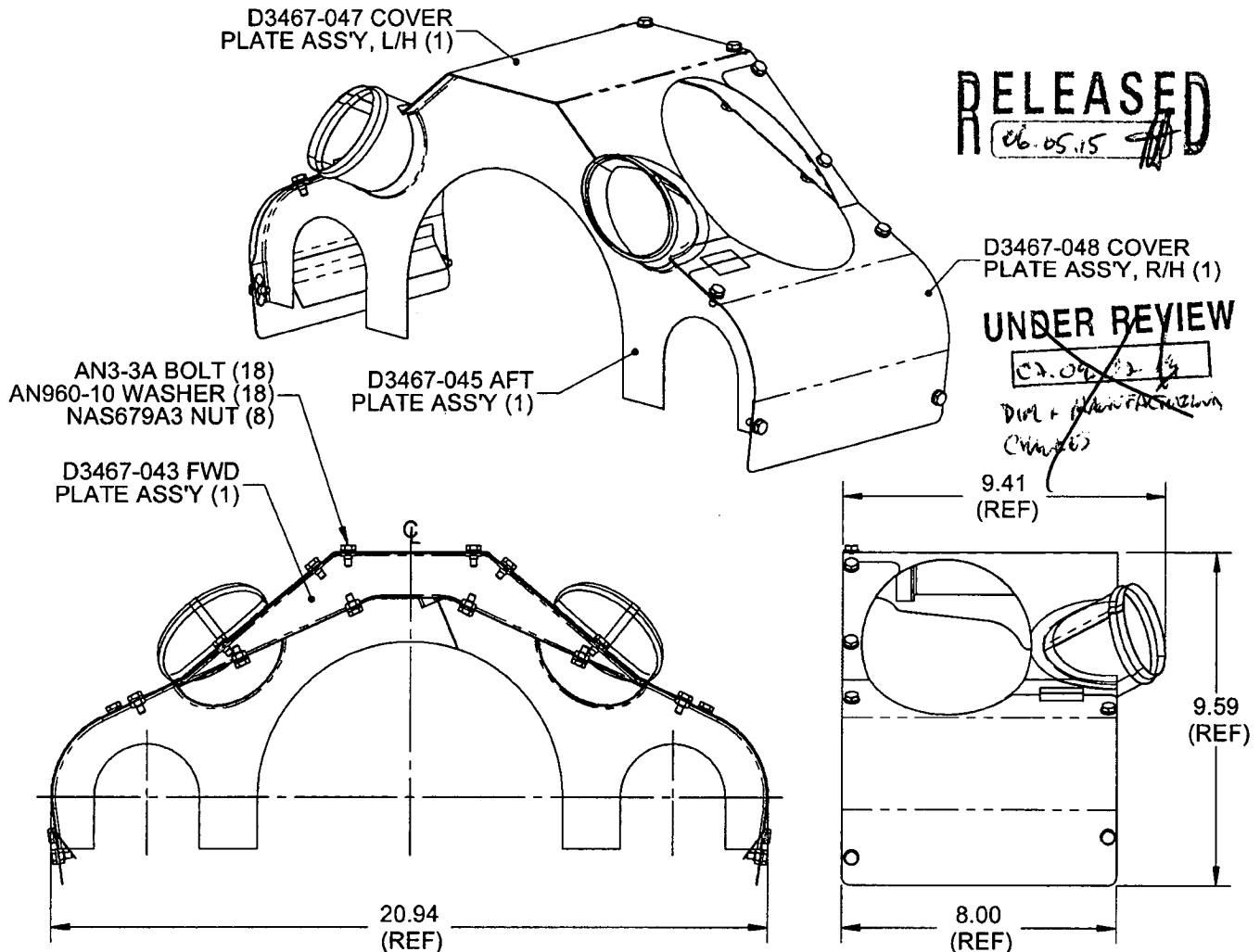
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. B SHEET 1 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:5
A	05.12.07	NEW ISSUE	
B	06.05.15	Ø0.250 & Ø0.203 WERE Ø0.194 ; UPDATED D3467-9F/-15F	



### D3467-041 SHROUD ASSEMBLY

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

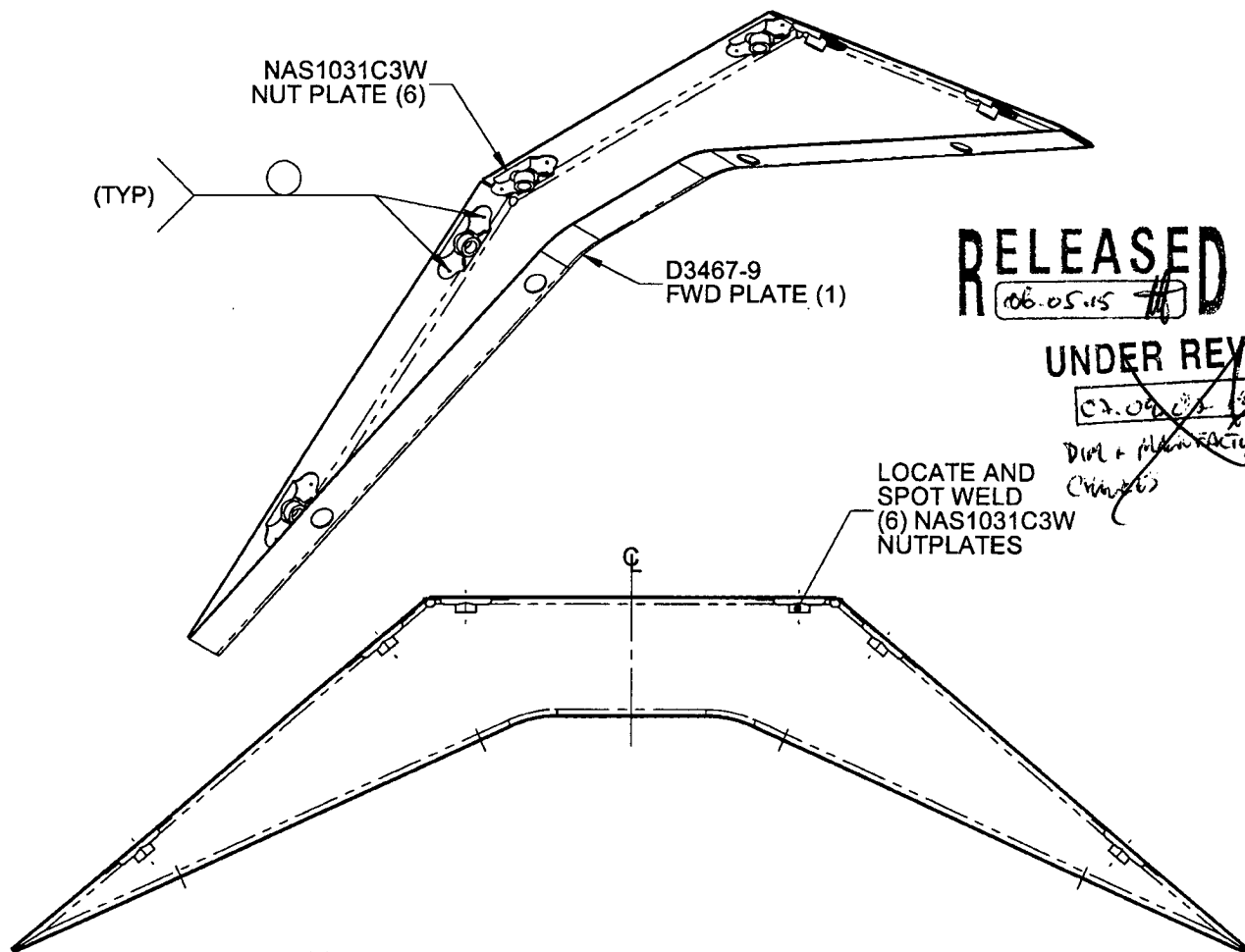
QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

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CHECKED 13	APPROVED 13	DRAWING NO. <b>D3467</b>	REV. B SHEET 2 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

**D3467-043 FWD PLATE ASSEMBLY****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

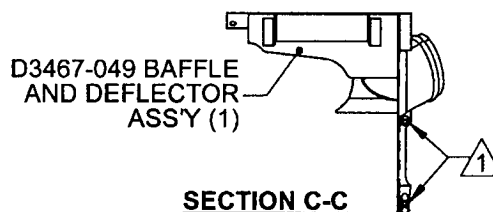
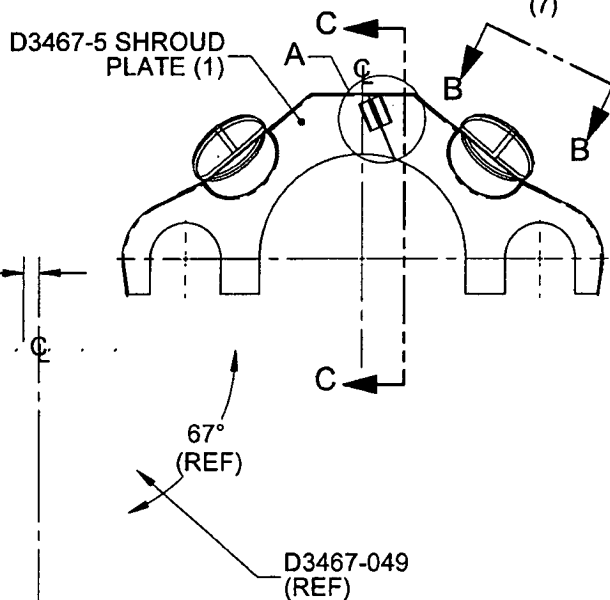
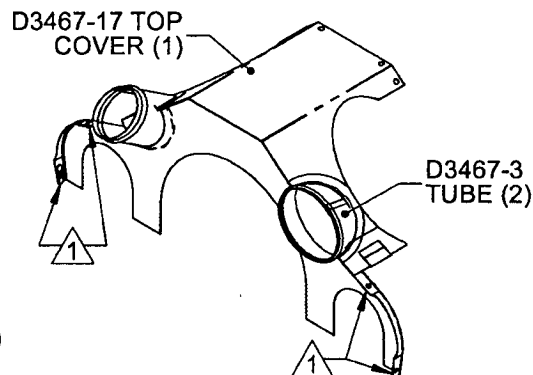
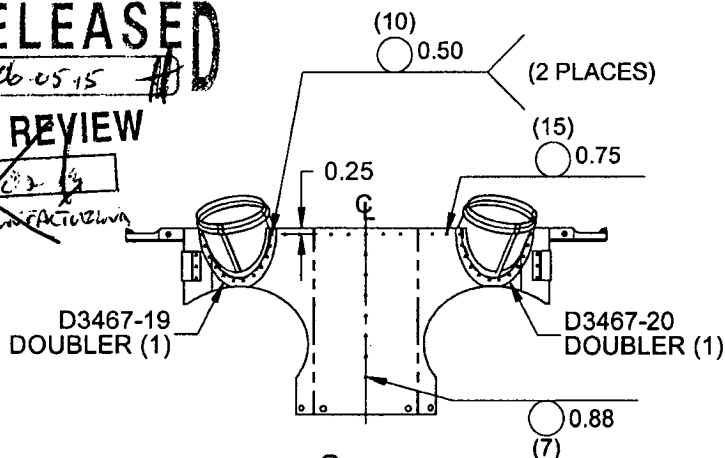
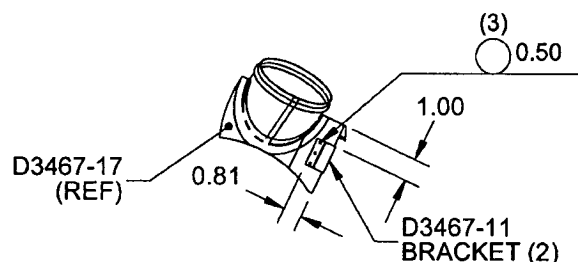
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DATE <b>06.05.15</b>	TITLE <b>SHROUD ASSEMBLY</b>		SCALE 1:8

**RELEASED**  
*06-05-15***UNDER REVIEW***Disc + planification  
Chassis***SECTION C-C****VIEW B-B: WELDING D3467-11**  
**D3467-047 NOT SHOWN FOR CLARITY**  
**(2 PLACES)****DETAIL A**  
SCALE 1:2**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

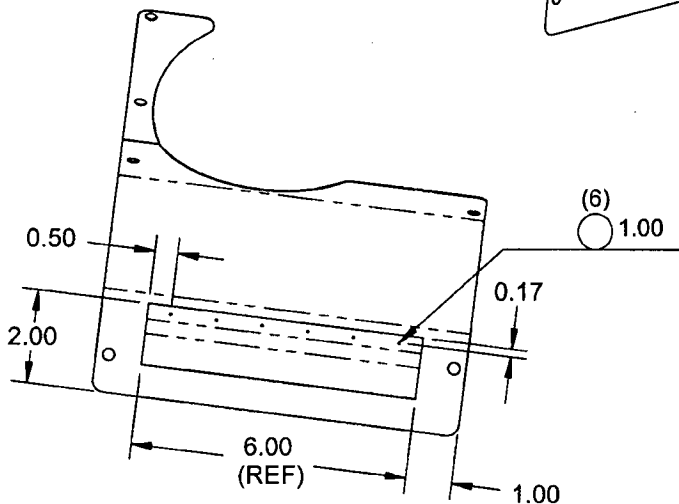
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CHECKED H	APPROVED H	DRAWING NO. D3467	REV. B SHEET 4 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

**RELEASED**  
06.05.15**UNDER REVIEW**02.09.15  
Dirt + plating removed  
(checked)D3467-1 COVER  
PLATE L/H, SHOWN  
(D3467-2 COVER  
PLATE R/H, OPPOSITE)D3467-7  
SEAL STRIP (1)**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**30° TOP COPY  
(REF) RETURN TO  
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WORK ORDER  
NO. 34490**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO  
0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

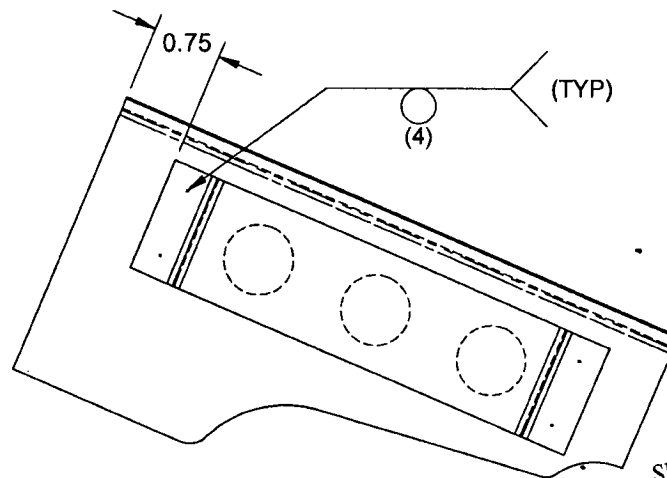
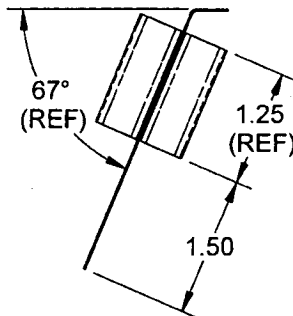
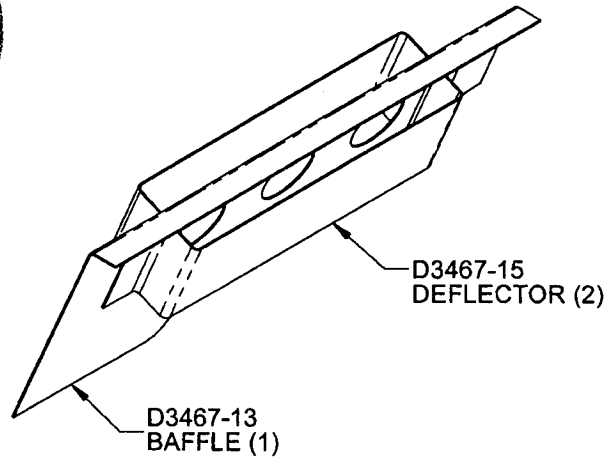
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
*06.05.15***UNDER REVIEW***02.06.15**Dist. & Assembly Instructions  
Cheng***D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

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NO. *34490*

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

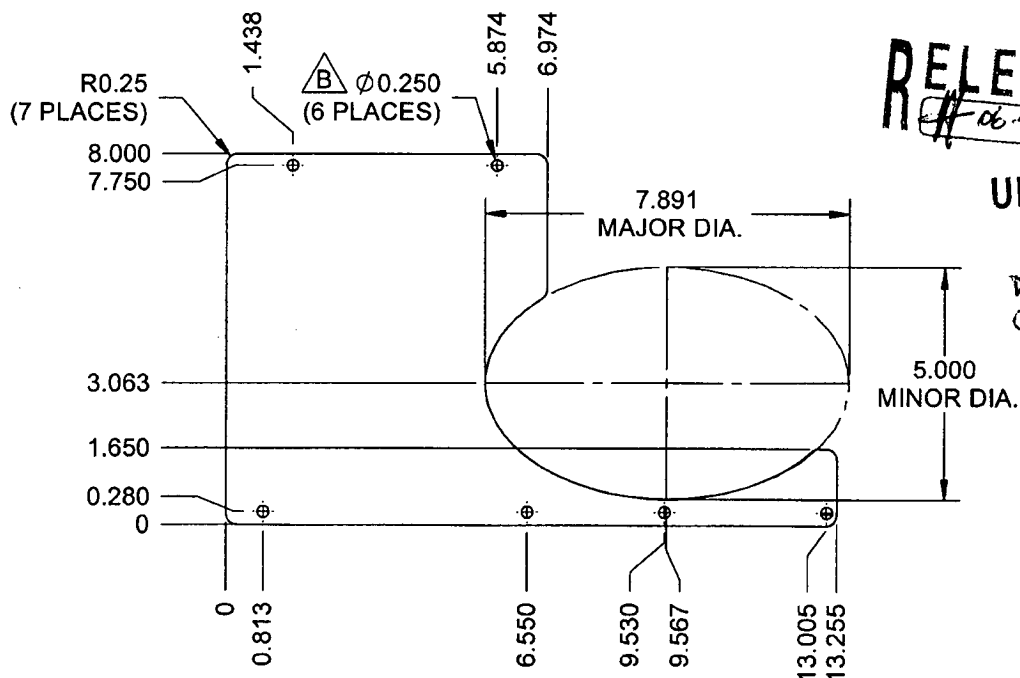
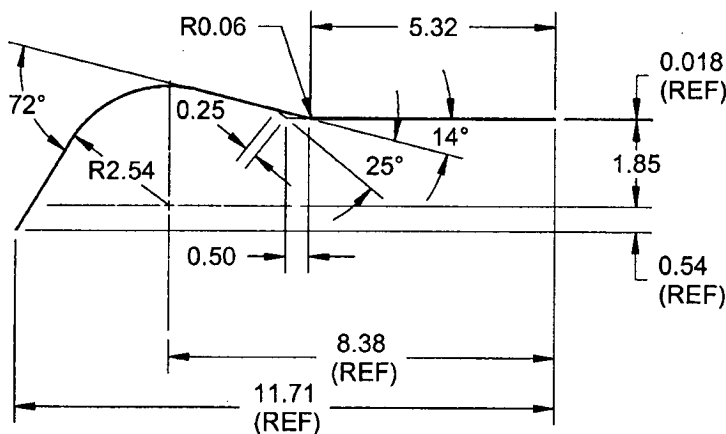
QTY -049	P/N	DESCRIPTION
	<b>D3467-049</b>	<b>BAFFLE &amp; DEFLECTOR ASSEMBLY</b>
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 6 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER PLATE**  
**D3467-2 R/H COVER PLATE (OPPOSITE)****D3467-1 L/H COVER**  
**PLATE ISOMETRIC VIEW.**  
**D3467-2 R/H COVER**  
**PLATE (OPPOSITE)**  
SCALE 1:8**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

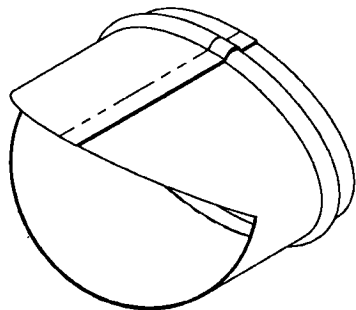
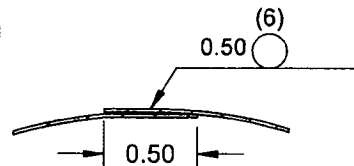
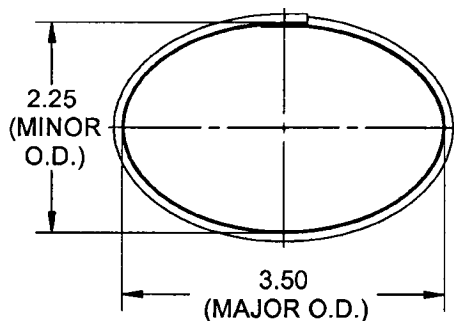
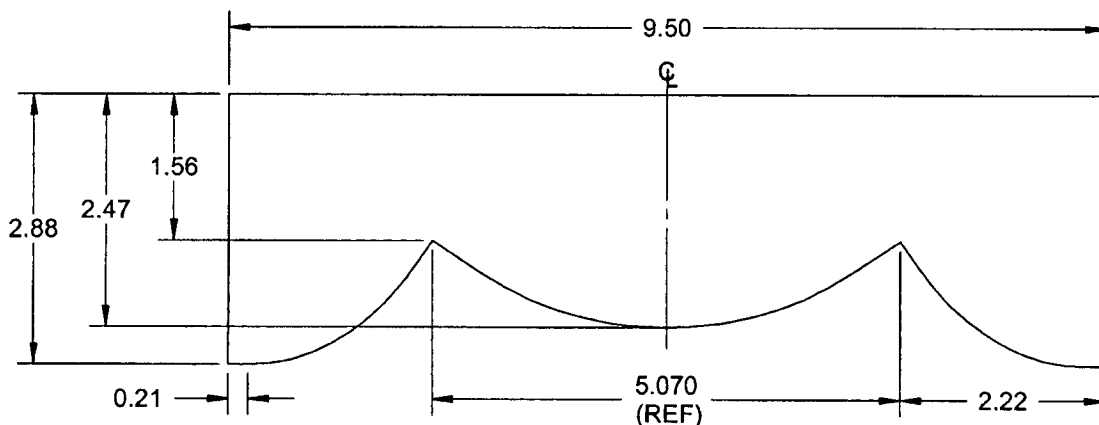
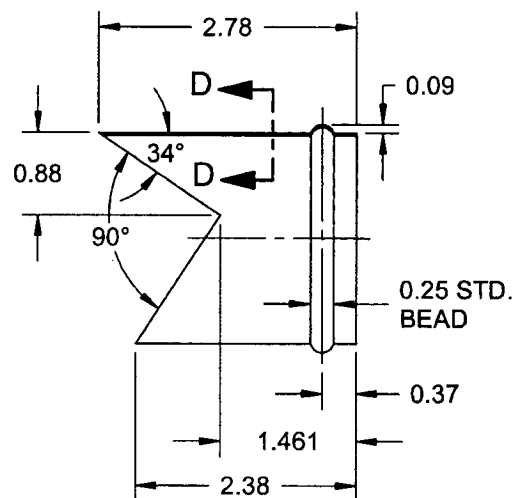
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DESIGN <i>JB</i>	DRAWN BY <i>JB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 7 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
*06.05.15***UNDER REVIEW***07.04.15*  
*Dist. + Material*  
*(Ching's)***SECTION D-D**  
SCALE 1:1**D3467-3 TUBE DETAIL****D3467-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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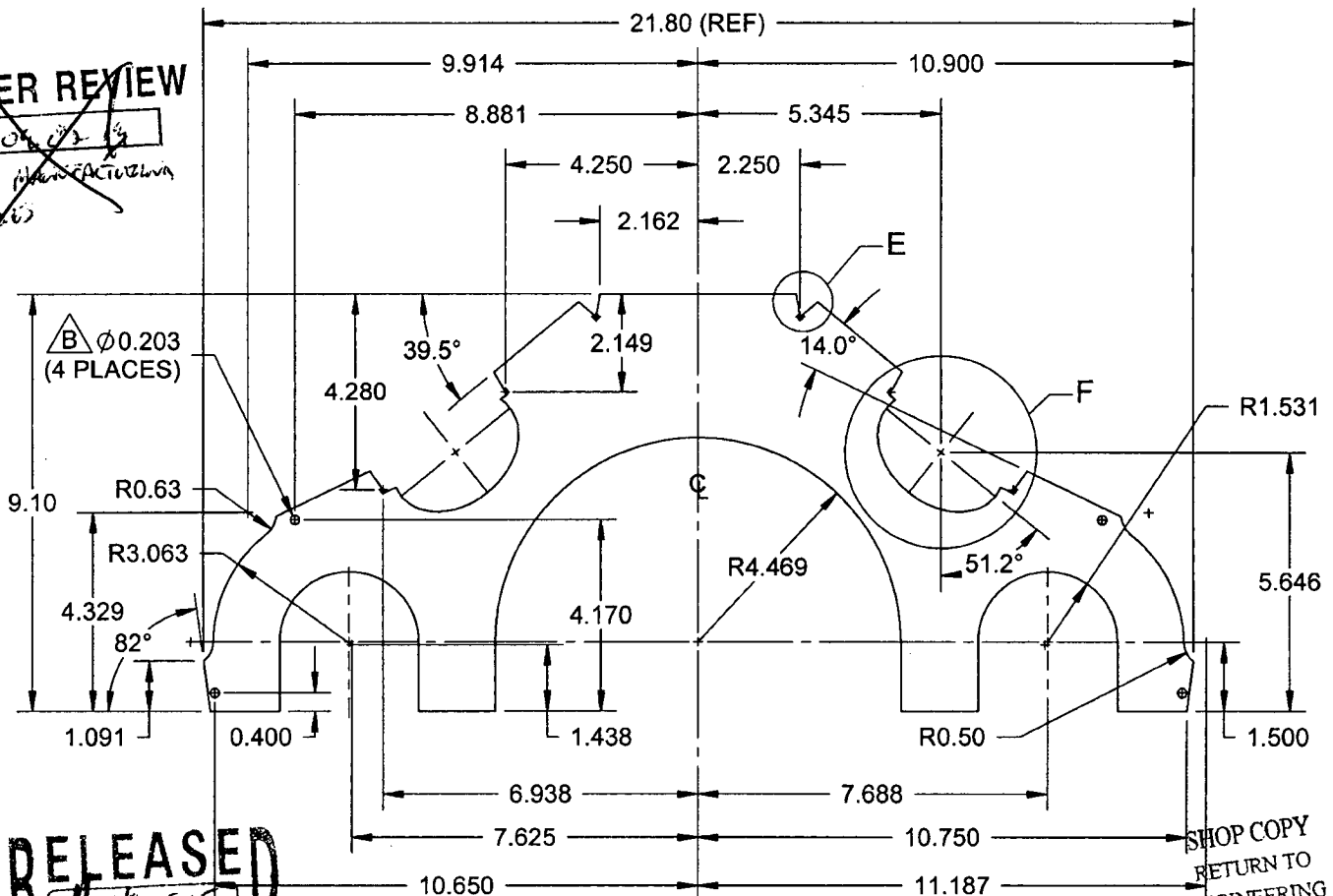
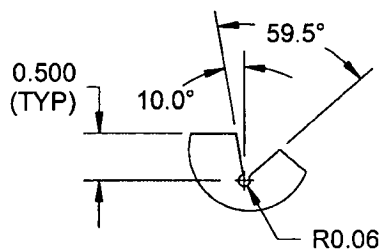
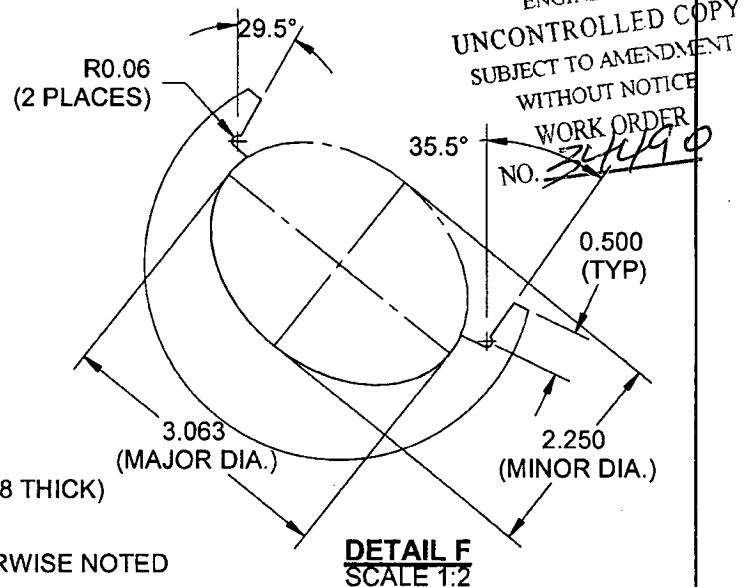
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 8 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8

**UNDER REVIEW**

*CT. 06.05.15*  
*Not a final production*  
*Change*

**RELEASED**  
*06.05.15***DETAIL E**  
SCALE 1:2**DETAIL F**  
SCALE 1:2**D3467-5F AFT PLATE FLAT PATTERN****NOTES:**

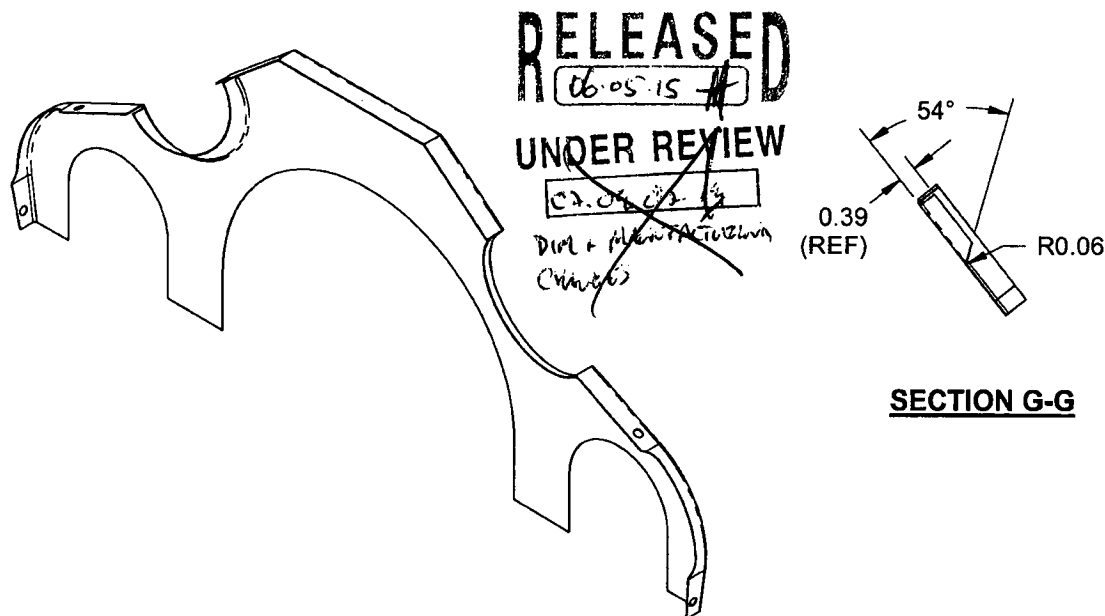
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019  
(ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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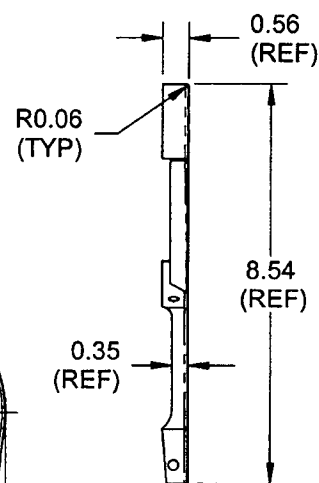
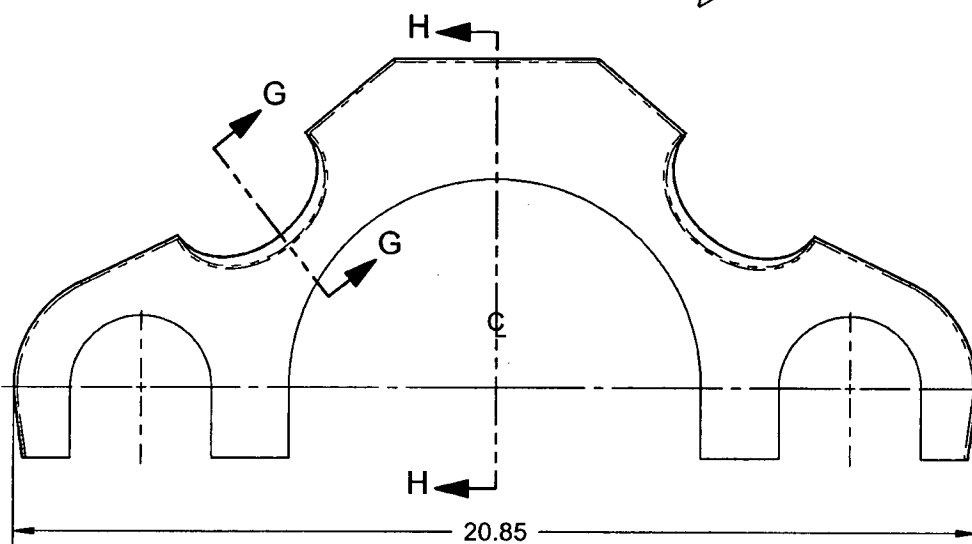
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>
DATE <b>06.05.15</b>	TITLE <b>SHROUD ASSEMBLY</b>	REV. B SHEET 9 OF 15 SCALE 1:4



**SECTION G-G**



**SECTION H-H**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE  
WORK ORDER  
NO. *34490*

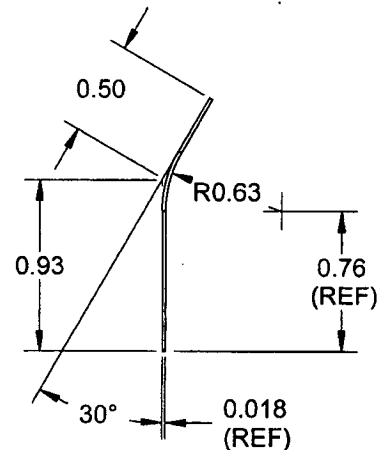
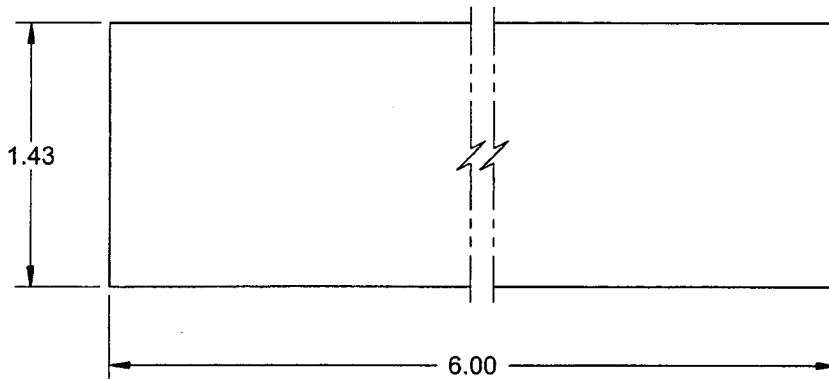
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:1

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06.05.15



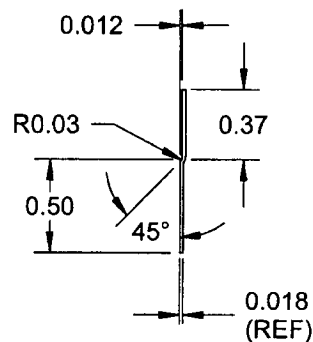
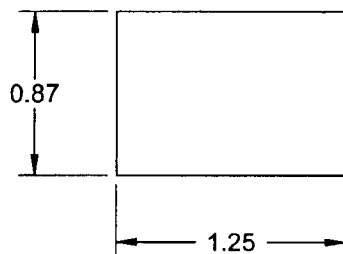
UNDER REVIEW

*[Signature]*

*Dirt + Material Selection  
Change*

**D3467-7F SEAL STRIP  
FLAT PATTERN**

**D3467-7 SEAL STRIP  
BENDING DETAIL**



**D3467-11F BRACKET  
FLAT PATTERN**

**D3467-11 BRACKET  
JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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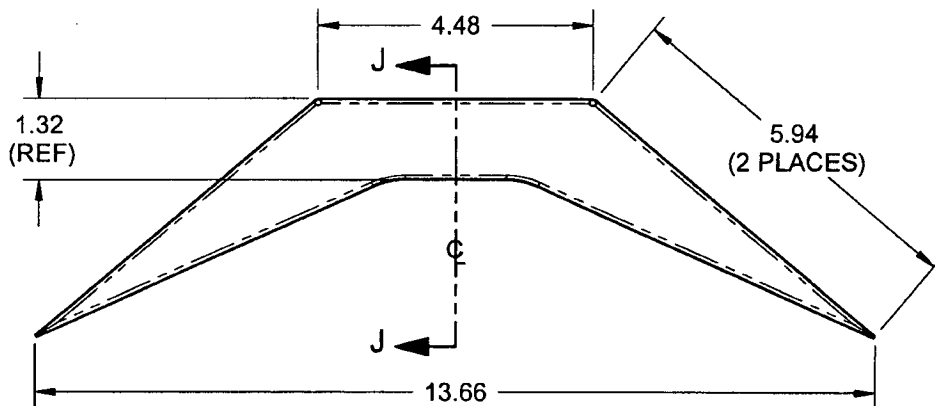
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DATE <b>06.05.15</b>	TITLE <b>SHROUD ASSEMBLY</b>	REV. B SHEET 11 OF 15 SCALE 1:3

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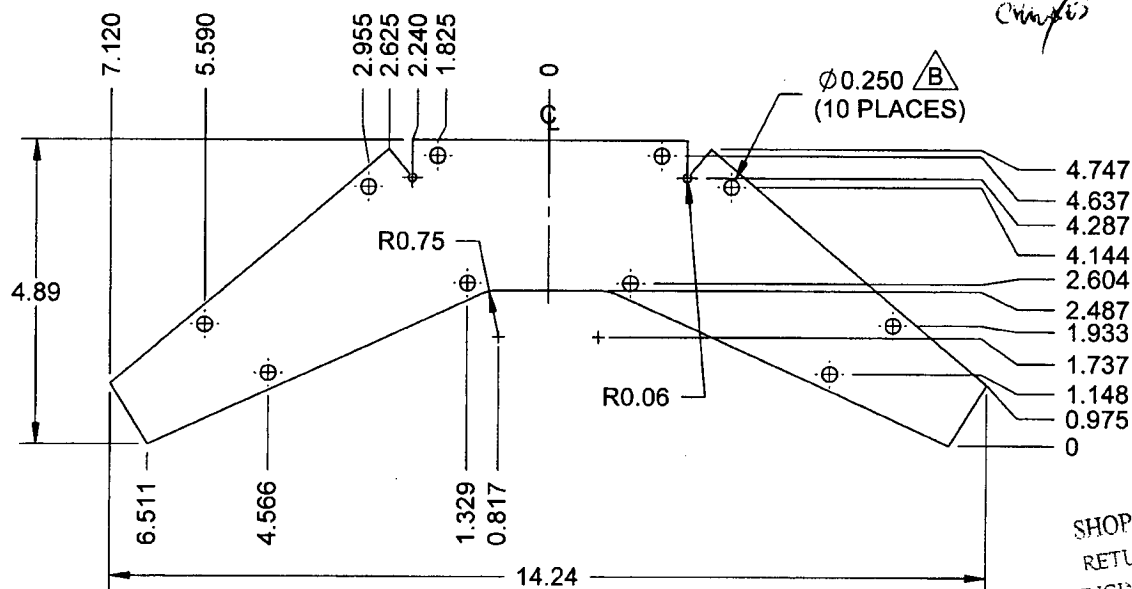
**D3467-9 FWD PLATE BENDING DETAIL**

**SECTION J-J**

**UNDER REVIEW**

*[Signature]*

*Dim + Location Change*



**D3467-9F FWD PLATE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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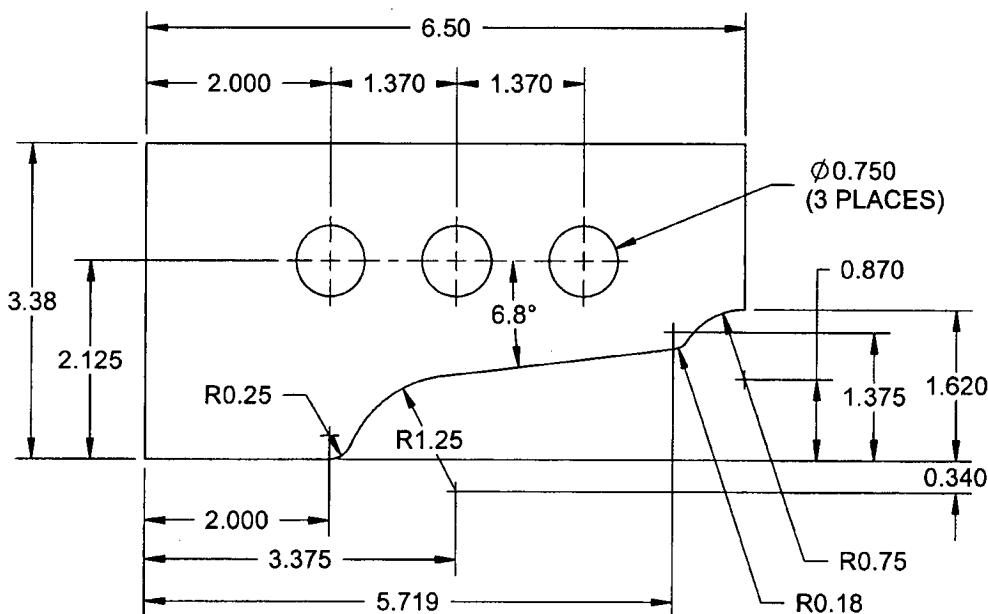
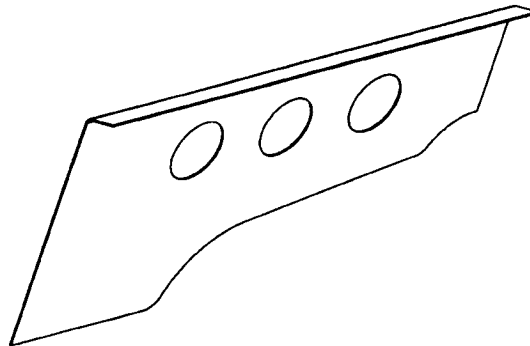
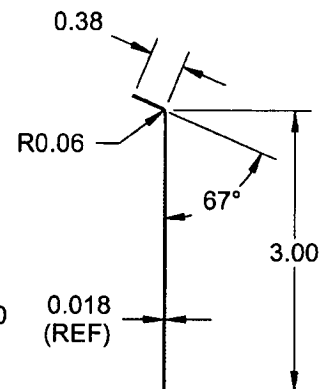
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

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*[Signature]* 06.05.15**UNDER REVIEW**

07.04.15

DIP + MANUFACTURING  
CHECKED**D3467-13F BAFFLE**  
**FLAT PATTERN****D3467-13 BAFFLE**  
**BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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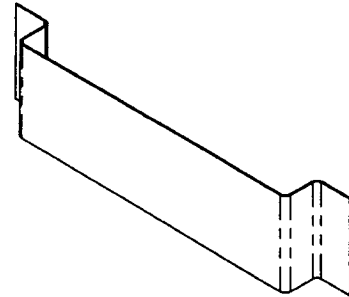
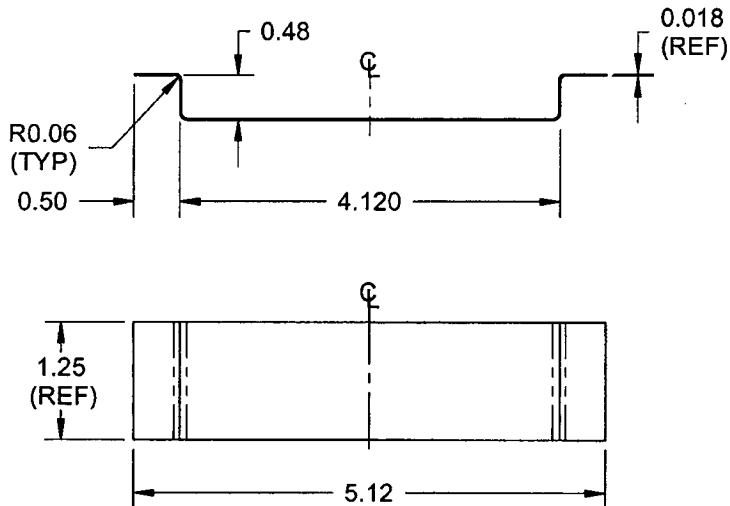
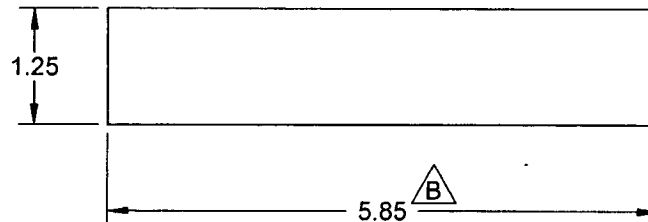
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

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*06.05.15***UNDER REVIEW***02.09.15*  
*Dir + Planning*  
*Crane***D3467-15 DEFLECTOR BENDING DETAIL****D3467-15F DEFLECTOR FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

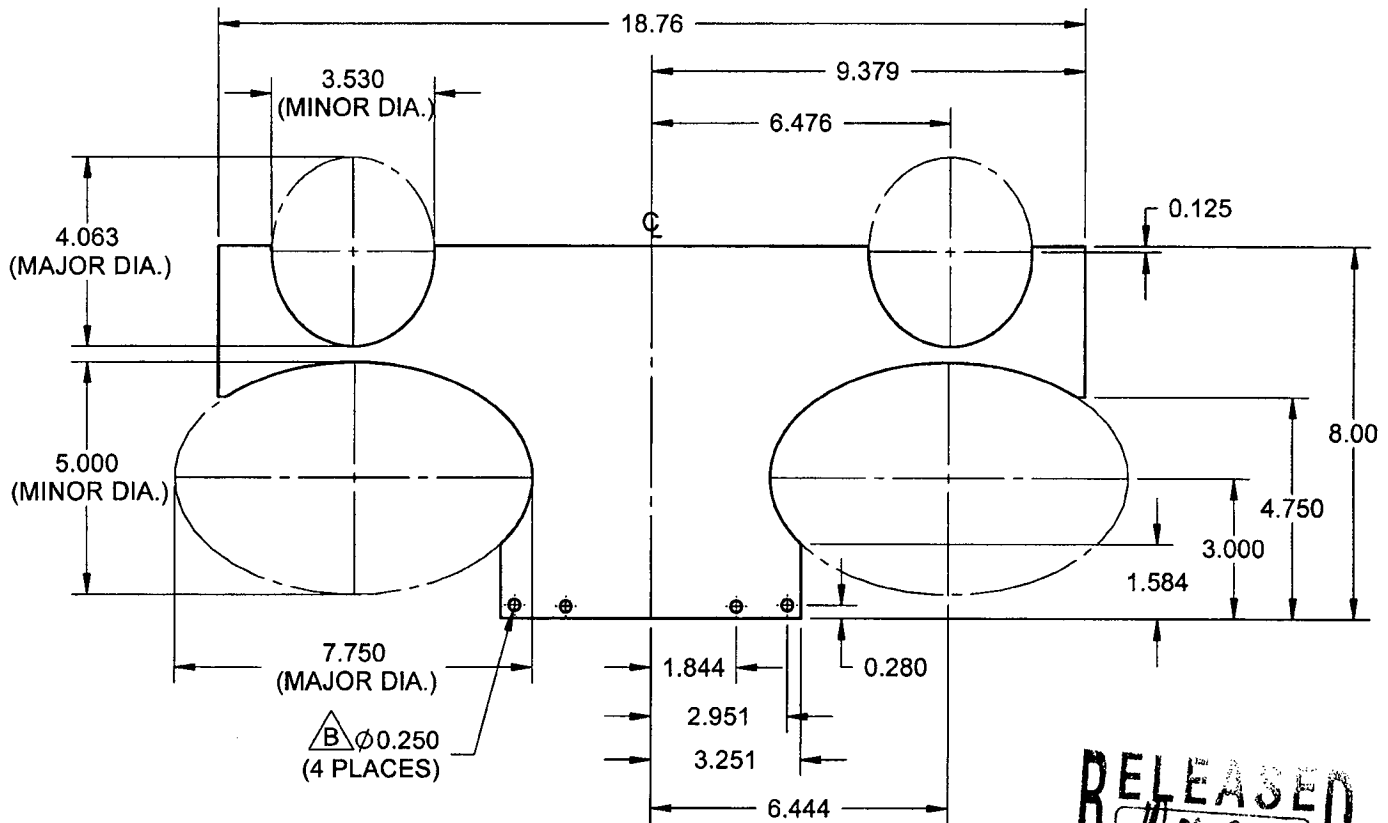
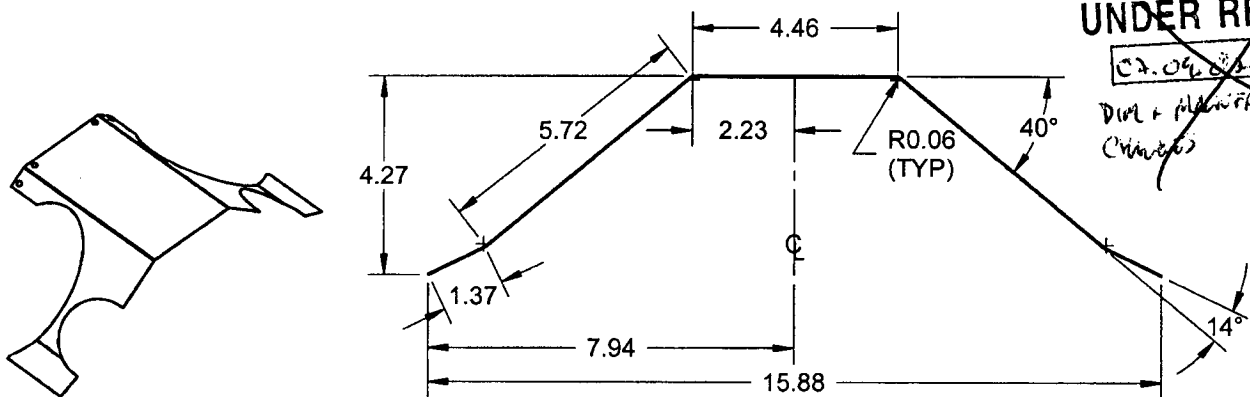
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4

**D3467-17F TOP COVER FLAT PATTERN****D3467-17 TOP COVER BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

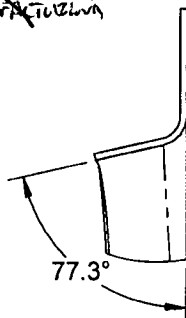
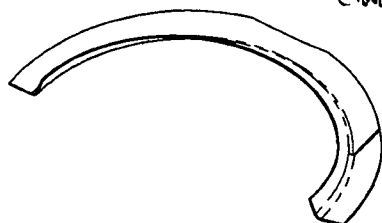
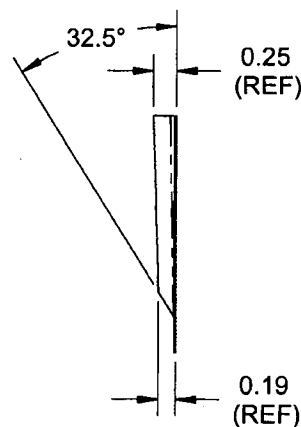
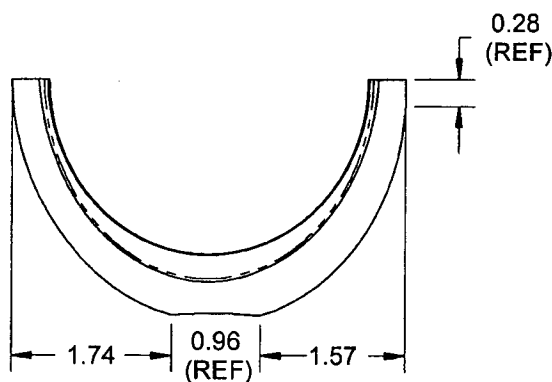
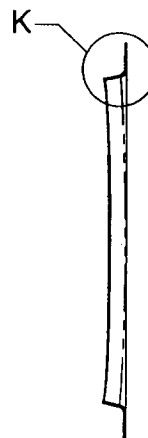
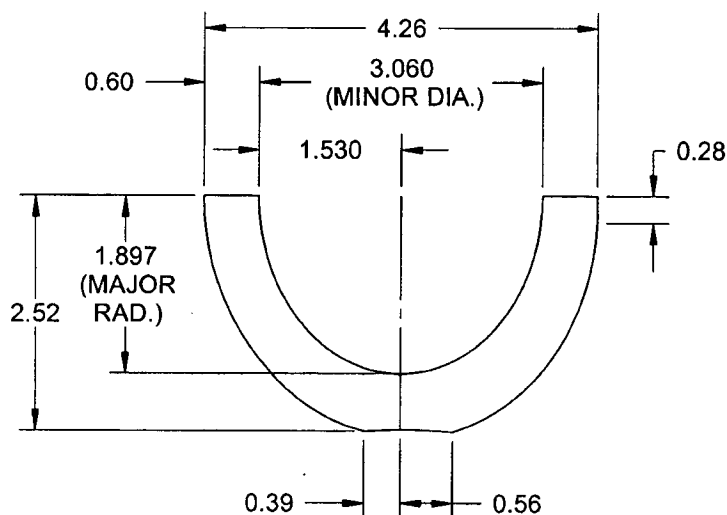
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
*06.05.15***UNDER REVIEW***02.09.15**Dir. + [Signature]*  
*(11/15)***DETAIL K**  
SCALE 1:2**D3467-19 DOUBLER, L/H SHOWN**  
**D3467-20 DOUBLER, R/H OPPOSITE**

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**D3467-19F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 10

EMPLOYEE: Melanie Fautsch

PART NUMBER: D3467-049

JOB NUMBER: B 34490

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium

## TEST RESULTS

	PASS	FAIL	
VISUAL:	[ / ]	[ ]	
PENETRATION:	[ / ]	[ ]	
FULL STRENGTH:	[ / ]	[ ]	PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/01/01

QUALIFIER: JB